

Work Order ID 66058

Thursday, February 03, 2011 11:41:20 AM

Page 1

Item ID: D4317-011 *change part number* Accept

Revision ID: PRELIM

Item Name: Cover Panel Retainer

Start Date: 2/4/2011 Start Qty: 12.00

Required Date: 2/11/2011 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Approvals: Process Plan: *MF* Date: *11-02-03* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4317	PA1
-------	-----

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4317-9)

Dwg Rev: *PA1*

Prog Rev: *PA1*

304 .063

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-2-4

11-2-4

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, February 03, 2011 11:41:20 AM

Page 2

Accept

Revision ID: PRELIM

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Start Date: 2/4/2011 **Start Qty:** 12.00

Required Date: 2/11/2011 **Req'd Qty:** 12.00

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Cust Item ID:

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00 - inspector to PA1

QC

Memo

0.00

Quality Control

130

0.00

Small Fab -

Memo

0.00

Small Fab

- 1- C'sink holes as per dwg
- 2- Deburr holes if necessary
- 3- Install nut plate

140

QC5- Inspect part completeness to step on W/O

0.00 - inspection to

QC

Memo

0.00

Quality Control

Sumner

ES4/02/07 (12)

⑦ 2

W/O:		WORK ORDER CHANGES					
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RESEARCH DESIGN AND METHODS

Page 3

Accept

[illegible]**Setup Start**

Stop

**Cust Item ID:**

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

Identify as per dwg & Stock Location:

0.00

[illegible]

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11/2/03 AUTH 1

RELEASED _____ DATE _____

used
on
w/o

mf
11-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 11:41:17 AM

Page 1

Work Order ID: 66058

Parent Item: D4317-01041

Parent Item Name: Cover Panel Retainer




Start Date: 2/4/2011

Required Date: 2/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 11.02.02 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	227.0800	0.0625	0.789474			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT		227.08							
				111323		0							
				116623		227.08							
MS20426AD3-4  RIVET		Purchased	No			130	Each	5,477.000	2	24			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		5477							
				104374		1477							
				110398		4000							
MS21075L4  Nutplate		Purchased	No			130	Each	71.0000	1	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST303		21							
				115837		21							
				ST353		50							
				115908		50							

18152-4

(12)

116623

24
EFS 11/02/07

24

12
EFS 11/02/07

12

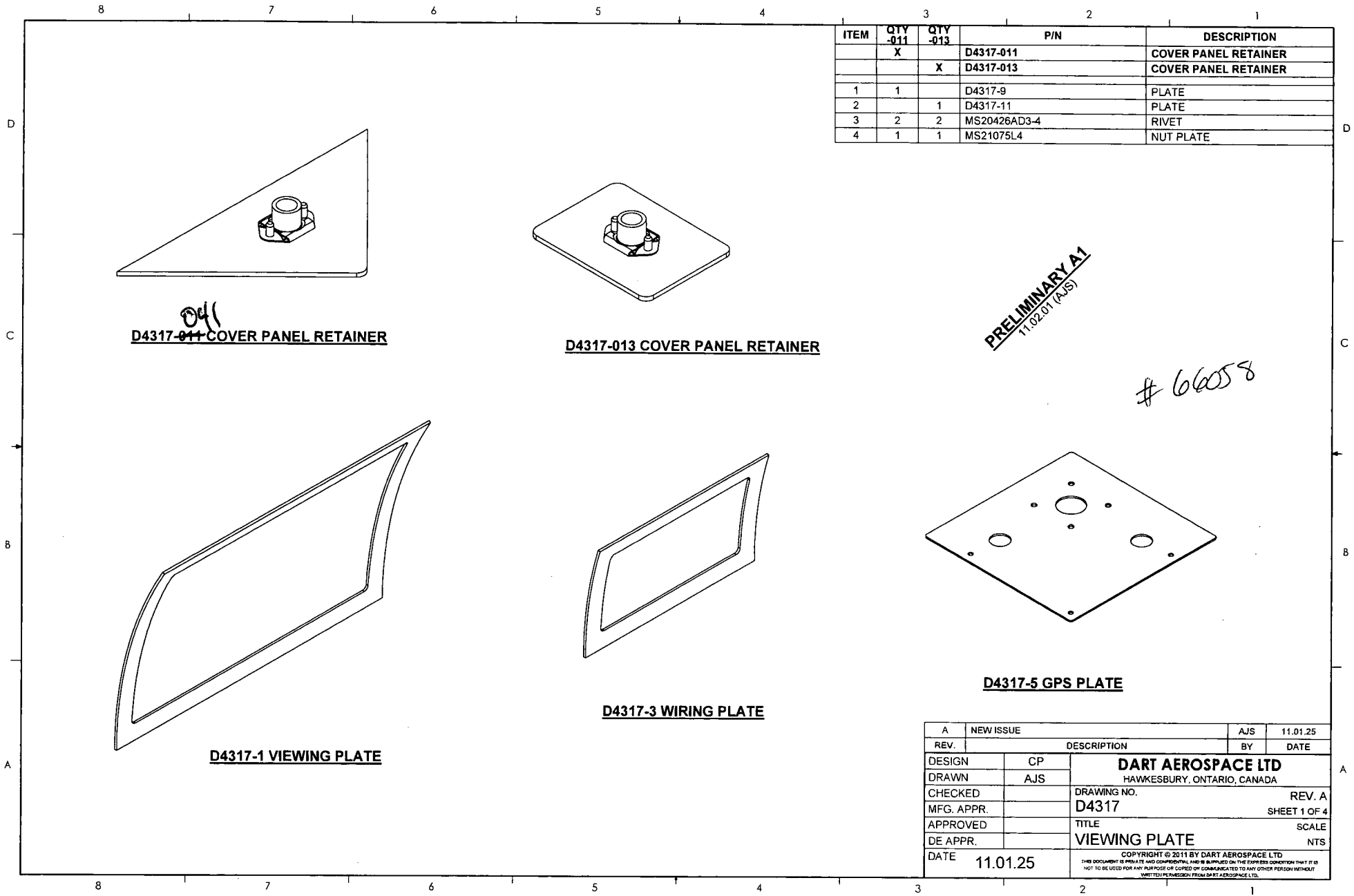
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



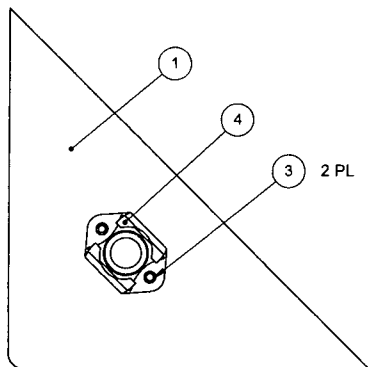
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

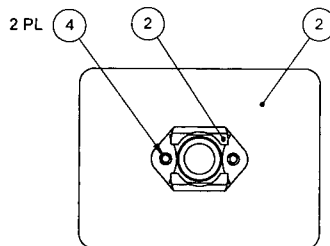
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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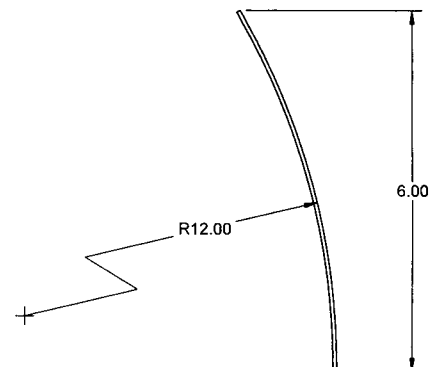
NOTE: Date & initial all entries



D4317-011 COVER PANEL RETAINER

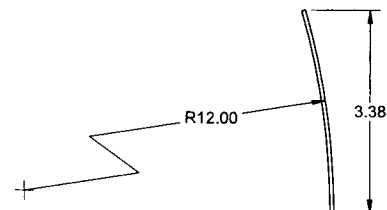


D4317-013 COVER PANEL RETAINER



D4317-1 VIEWING PLATE

#66058



D4317-3 WIRING PLATE

NOTES:

- 1) MATERIAL -1: MAKE FROM D4317-1F
-3: MAKE FROM D4317-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4317-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -011: 0.1 lbs
-013: 0.06 lbs
-1 & -3: SEE FLAT PATTERN WEIGHTS

PRELIMINARY A1
11.02.01 (AJS)

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4317	REV. A
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		VIEWING PLATE	NTS
DATE	11.01.25	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

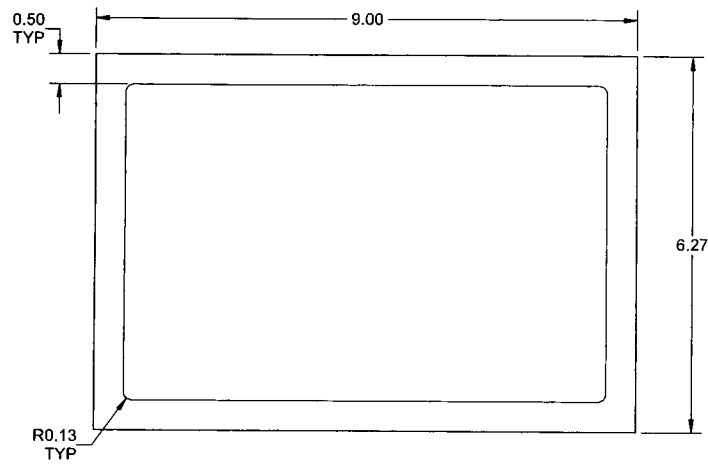
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

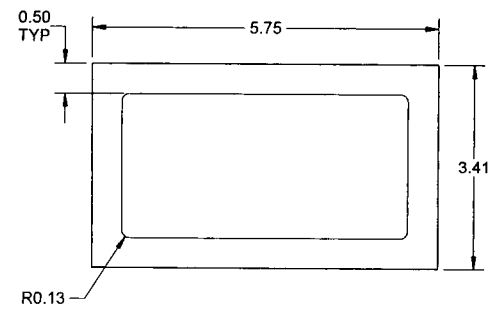
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY A1
11.02.01 (AJS)



D4317-1F VIEWING PLATE



D4317-3F WIRING PLATE

#66058

NOTES:

- 1) MATERIAL -1F, -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.060 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA OR DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NA
- 7) WEIGHT -1: 0.26 lbs
-3: 0.14 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4317	REV. A
MFG. APPR.		TITLE VIEWING PLATE	SCALE NTS
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DE APPR.			
DATE	11.01.25		

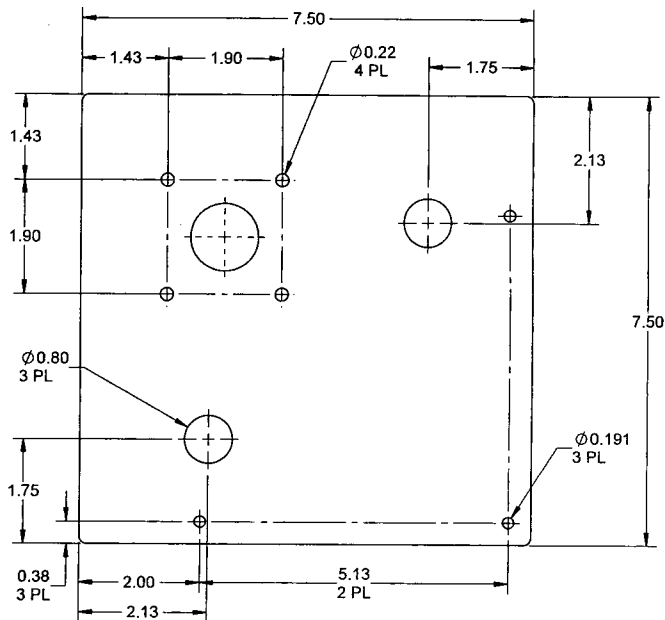
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

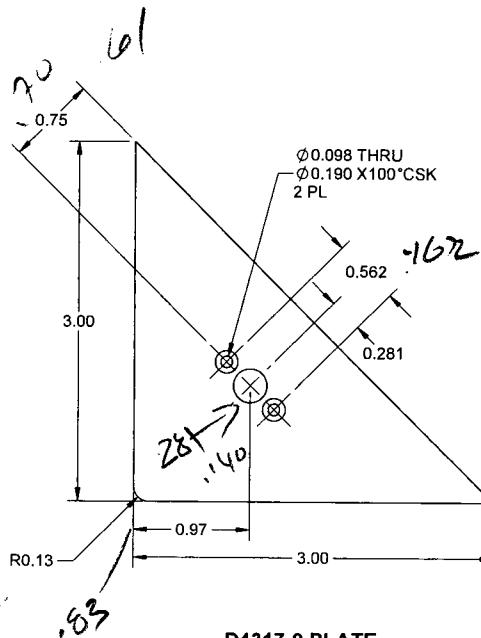
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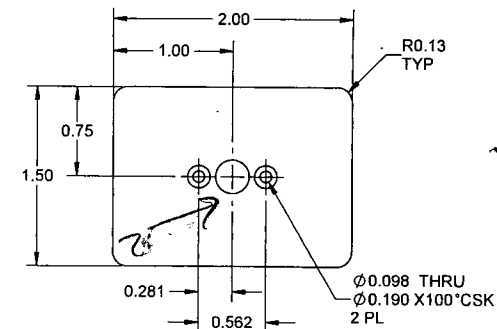


D4317-5 GPS PLATE

D4317-7 GPS PLATE



D4317-9 PLATE



D4317-11 PLATE

#66058

NOTE:

1) MATERIAL -5, -7, -9 & -11: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.060 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA OR DART SPEC M304S16GA

-7: AISI 4130N STEEL SHEET, 0.060 THK
PER MIL-S-18729 OR AMS 6350 OR AMS 6351
REF DART SPEC M4130N-S.060

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NA

7) WEIGHT -5 & -7: 0.97 lbs

-9 & -11: SEE ASSEMBLED WEIGHT

PRELIMINARY A1
11.02.01 (AJS)

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4317	REV. A
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE VIEWING PLATE	SCALE NTS
DE APPR.			
DATE	11.01.25	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: Alan Stocker <astocker@dartaero.com>
Sent: February 7, 2011 11:22 AM
To: llacelle@dartaero.com; kjohnston@dartaero.com; dduval@dartaero.com
Cc: Mike Petsche
Subject: NRCan Basket Part # Updates

Good Morning,

Parts have not been changed but some – numbers have been updated as follows:

D4316-3 is now: D4316-1

D4317-011 is now: D4317-041

D4317-013 is now: D4317-043

D4318-011 is now: D4318-041

~~6041 - 66057~~

~ 66058 —

66061 —

66065 —

Sorry for the errors

Alan Stocker

Mechanical Designer
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
CANADA K6A 1K7
(613) 632 5200 x 229
astocker@dartaero.com
<http://www.dartaero.com/>

W/O:		WORK ORDER CHANGES					
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Work Order Summary

Monday, February 07, 2011 12:57:50 PM

Page 1 of 1

Criteria : Work Order ID: 66057 Item ID: D4316-041 Product Family SMALL FAB
Work Order Start Dates 2/4/2011 to 2/4/2011 11:59:59 PM Work Order Required Dates 2/11/2011 to
2/11/2011 11:59:59 PM
All References
Work Order Status Released

Work Order ID 66057 Required Qty 4.0000 Status Code Released
Item ID D4316-041 Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Tube Assembly
Current Acct Value \$14.008 Sales Order ID

Start Date 2/4/2011 Required Date 2/11/2011 Completed Date
Standard ** Actual ** ** Acct. Value ** ** Variance ** ** Variance % **

<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
Material	\$0.000	\$0.000	\$4.263	\$4.263	100.00%
Labor	\$0.000	\$0.000	\$3.792	\$3.792	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$0.000	\$0.000	\$5.953	\$5.953	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$0.000	\$0.000	\$14.008	\$14.008	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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